

Date: Tuesday, 16/09/2008 1:22:17 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER				
Job Number	: 42028							
Estimate Number	: 11178							
P.O. Number	:			Part Number	: D32931			
This Issue	: 16/09/2008	S.O. No. :		Drawing Number	: D3293 REV A			
Prsh Rev.	: NC			Project Number	: N/A			
First Issue	: / /	Type :		Drawing Revision	: A			
Previous Run	: 41794			Material	:			
Written By	:			Due Date	: 30/09/2008			
Checked & Approved By	<u>JUL 08-9-16</u>			Qty:	12 Um: Each			
Comment	: Est:A 04.08.24 New issue KJ/JLM Est Rev:B Now on Waterjet 06-11-02 JLM							

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S080	2024-T3 .080 sheet	
		Comment: Qty.: 1.9177 sf(s)/Unit Total : 23.0126 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.080" thick (M2024T3S.080) Identify for D3293-1 Batch: <u>109404</u>	  <i>1B 8-9-30</i>
			(12)
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3293 Dwg Rev: <u>A</u> Prog Rev: <u>A</u>	  <i>1B 8-9-30</i>
		2-Deburr if necessary	  <i>1B 8-9-30</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	  <i>1B 8-9-30</i>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	  <i>1B 8-9-30</i> (ER)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

1/1 Done at step #2/2

6.0 QC5



INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/8/30 (R12)

7.0 HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

EL

08-10-02

X12

8.0 POWDER COATING



POWDER COATING



M105642

(12X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 12-00

06

OVEN TEMPERATURE: 325

30

FINISH TIME: 12-30

ML

08/10/03

9.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



(12)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

08/10/03

10.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

L S/10/06 (12)

11.0 QC21



FINAL INSPECTION/W/O RELEASE



08/10/08 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08.10.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	42028
Description: Doubler	Part Number:	D3293-1
Inspection Dwg: D3293	Rev: A	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>B</u>	Audited by:	<u>C</u>	Prototype Approval:	N/A
Date:	8-9-30	Date:	08/04/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	SJL

